

* Attachment — Marked up copy showing status

Serial No. 10/621,830

Reply to Office Action of April 6, 2006

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IN THE CLAIMS:

Please amend the claims as follows:

1-30 (cancelled)

~~withdrawn~~

31. ~~(new)~~ A method of molding a grip cap for a container, comprising the steps of:

(1) injecting a first thermoplastic material into a mold to form a cap shell having a top wall and a skirt depending down from the top wall to a lower rim, the cap shell for receiving a neck of the container, the cap shell having an outer surface and an underside including the lower rim; and

(2) injecting a second thermoplastic material into the mold to form a grip layer of a material different from a material of the cap shell, the grip layer having a plurality of vertically extending ribs, fused to the cap shell during molding, and raised from the outer surface of the cap shell in spaced relation, the ribs exposing the cap shell therebetween and extending along the skirt between the top wall and the lower rim, the ribs being resilient relative to the cap shell.

~~withdrawn~~

32. ~~(new)~~ The method of claim 31, wherein the second thermoplastic material is an elastomeric material.

~~withdrawn~~

33. ~~(new)~~ The method of claim 31, wherein the first thermoplastic material is polypropylene.

~~withdrawn~~

34. ~~(new)~~ The method of claim 31, wherein the ribs are spaced equi-angularly about an axis about which the cap shell is concentric.

~~withdrawn~~

35. ~~(new)~~ The method of claim 31, wherein the grip layer further includes a pad integrally molded to an upper surface of the cap shell top wall.

~~withdrawn~~

36. ~~(new)~~ The method of claim 35, wherein the pad and the ribs join together at the pad.

~~withdrawn~~

37. ~~(new)~~ The method of claim 35, wherein the pad has a diameter less than the top wall of the cap shell.

~~withdrawn~~
38. (new) The method of claim 35, wherein the cap shell is molded to extend upward through the pad to present raised indicia.

~~withdrawn~~
39. (new) The method of claim 31, wherein the ribs join at a gasket of the second thermoplastic material extending along the underside of the lower rim.

~~withdrawn~~
40. (new) The method of claim 31, wherein the cap shell has one or more flanges surrounded by the skirt and extending down from the top wall sized to directly engage the container.

~~withdrawn~~
41. (new) The method of claim 31, wherein the cap shell has one or more flanges surrounded by the skirt and extending down from the top wall and further including the step of fitting an inner cap to the flanges, the inner cap adapted to be removably mounted over an opening of the container.

~~withdrawn~~
42. (new) The method of claim 31, wherein the mold has a first, second and third part and wherein

the injecting of the first thermoplastic material is into a combination of the first and second parts of the mold such that the outside of the cap shell is formed by the first mold part and the inside of the cap shell is formed by the second mold part; and wherein

the injecting of the second thermoplastic material is into a combination of the third and second parts of the mold after interchanging the first part of the mold with the second part of the mold; and further including the step of:

allowing the cap shell to shrink on the first die part so that the lower rim is spaced from an adjacent surface of the first die part before injection of the second thermoplastic material.

~~withdrawn~~
43. (new) The method of claim 42, wherein the grip layer is formed by injecting an elastomeric resin between the cap shell and the second and third die parts.

~~withdrawn~~
44. (new) The method of claim 42, wherein the cap shell is formed by injecting a non-elastomeric resin between the first and second die parts.

~~withdrawn~~
45. (new) A two-shot method of making a grip cap for a container, comprising the steps of:

molding in a die having a first part and a second part a cap shell conforming to the interior of the die so as to have a top wall and a skirt bounded by a lower rim at an angle to an outer surface of the skirt;

supporting the cap shell on the first die part; interchanging the second die part with a third die part;

allowing the cap shell to shrink on the first die part so that the lower rim is spaced from an adjacent surface of the first die part;

joining the first and third die parts with the cap shell therebetween; and
molding a gasket extending along the lower rim in the space between the lower rim and the adjacent surface of the first die part.

IN THE CLAIMS:

Please amend the claims as follows:

1-17 . (canceled)

~~46~~ ^{new} 18. (~~currently amended~~) A grip cap for a container, comprising:

a cap shell having a top wall and a skirt depending down from the top wall to a lower rim, the cap shell for receiving a neck of the container, the cap shell having an outer surface and an underside including the lower rim; and

a grip layer of a material different from a material of the cap shell, the grip layer having a plurality of vertically extending ribs fused to the cap shell and raised from the outer surface of the cap shell in spaced relation, the ribs exposing the cap shell therebetween and extending along the skirt between the top wall and the lower rim, the ribs being resilient relative to the cap shell;

wherein the ribs join at a gasket formed of the same material as the ribs and extending along the underside of the lower rim and fused to the lower rim.

~~47~~ ^{new} 19. (~~previously presented~~) The grip cap of claim ~~18~~ ⁴⁶, wherein the cap shell is made of a thermoplastic material and the ribs are made of an elastomeric material.

~~48~~ ^{new} 20. (~~previously presented~~) The grip cap of claim ~~19~~ ⁴⁷, wherein the cap shell is polypropylene.

~~49~~ ^{new} 21. (~~previously presented~~) The grip cap of claim ~~18~~ ⁴⁶, wherein the ribs are spaced equi-
angularly about an axis about which the cap shell is concentric.

~~50~~ ^{new} 22. (~~previously presented~~) The grip cap of claim ~~18~~ ⁴⁶, wherein the grip layer further includes a pad integrally molded to an upper surface of the cap shell top wall.

~~51~~ ^{new} 23. (~~previously presented~~) The grip cap of claim ~~22~~ ⁵⁰, wherein the pad and the ribs are the same material and the ribs join together at the pad.

~~52~~ ^{new} 24. (previously presented) ⁵⁹ The grip cap of claim 22, wherein the pad has a diameter less than the top wall of the cap shell.

~~53~~ ^{new} 25. (previously presented) ⁵⁹ The grip cap of claim 22, wherein the cap shell is molded to extend upward through the pad to present raised indicia.

26. (cancelled)

~~54~~ ^{new} 27. (currently amended) The grip cap of ~~claim 26~~ claim 1, wherein the gasket and the ribs are the same material and wherein the ribs join together at the gasket.

~~55~~ ^{new} 28. (previously presented) ⁴⁶ The grip cap of claim 18, wherein the cap shell has one or more flanges surrounded by the skirt and extending down from the top wall that directly engage the container.

~~56~~ ^{new} 29. (previously presented) ⁵⁵ The grip cap of claim 28, wherein the one or more flanges engage an inner cap removably mounted over an opening of the container.

~~57~~ ^{new} 30. (previously presented) ⁴⁶ The grip cap of claim 18, wherein the grip cap is formed in a two-shot method including:

molding the cap shell in a die having a first part and a second part such that the cap shell conforms to the interior of the die;

supporting the cap shell on the first die part; interchanging the second die part with a third die part;

allowing the cap shell to shrink on the first die part so that the lower rim is spaced from an adjacent surface of the first die part;

joining the first and third die parts with the cap shell therebetween; and molding the grip layer integrally with the cap shell.